



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-742-053
Job Sheet 198599-A



Part No: D412-742-053

Job Qty: 2 pcs

Part Name: Repl. Skidtube, DART (Apical) Tri-Bag Float Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/23/19

Job Tracking No:

Due Date: 10/13/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: IIN-D412-742-2 REV.A IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER CHG002 (DSI 9800) DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
110	Packaging 1 - Pick Kit	2 pcs	10/13/19		0.00	0.00	Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	
							Packaging 1 - 29	
							Packaging 1 - 30	



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Container No: S216223



Part: D412-742-053

Job No: 198599-A

Serial No/Batch: S213816

Revision: A

Inspector:

Exp Date:

Instructions: FAA STC SR01583SE 18/10/17, TC STC SH05-

Plex 9/23/19 1:00 PM dart.lacelle.linda

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
115 Packaging 1-1 - Pick Kit - B4B 2 pcs	10/13/19	0.00 0.00			Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
120 QC 4	2 pcs	10/13/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
130 Packaging 3-1 - Stock - B4B	2 pcs	10/13/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	

AL B/11/19

DAS
78 NOV 13 2019
9-89

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	DAS
				Packaging 3 - 26 - B4B	78 NOV 13 2019
				Packaging 3 - 27 - B4B	9-89
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
135 DC - 1 - B4B	2 pcs	10/13/19	0.00 0.00	DC - 1 - B4B	21 NOV 13 2019
				DC - 2 - B4B	
140 QC 21 - SA	2 pcs	10/13/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 NOV 13 2019
				QC 21 - SA - 53	9-89

Part Op 110 - Packaging1-4 (Pick Kit)

Descriptions: 120 - QC4 (QC4- 100% Inspect kits for completeness)

130 - Packaging3-2 (Identify as per dwg & Stock Location:) Identify and pack for shipping as per PPP D412-742-053 Location :FG083

135 - DC (Document Control) Photocopy blue file and create labels per PPP D412-742-053 CHG002

140 - QC21 (QC21- Final Inspection - Work Order Release)NULL

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C44A	Bolt	30 Ea (15 ea)	110-Packaging 1 - Pick Kit	5193253
D5513-1	Bushing	60 pcs (30 ea)	110-Packaging 1 - Pick Kit	5209403
MS21043-3	Nut	30 Ea (15 ea)	110-Packaging 1 - Pick Kit	5209403
D412-742-055	Thru-Bolt Full-Length Standard Wearplates, Bell Medium - Fits LH or RH	2 pcs (1 ea)	115-Packaging 1-1 - Pick Kit - B4B	5209403
D5425-043	Float Skidtube Assembly	2 pcs (1 ea)	120-QC 4	5209403

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3C44A	30	142	0
	D5513-1	60	26	0
	MS21043-3	30	546	0
115-Packaging 1-1 - Pick Kit - B4B	D412-742-055	2	4	0
120-QC 4	D5425-043	2	11	0

Part Specifications
Specifications could not be found.

Plex 9/23/19 1:00 PM dart.lacelle.linda



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D412-742-053
Job Sheet 198599



Part No: D412-742-053

Job Qty: 4 pcs

Part Name: Repl. Skidtube, DART (Apical) Tri-Bag Float Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Due Date: 9/13/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: IIN-D412-742-2 REV.A IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER CHG002 (DSI 9800) DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		9/13/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3	DAS	
							Packaging 1 - 4	74	
							Packaging 1 - 5	9-89	SEP 13 2019
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



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Container No: S213816



Part: D412-742-053

Job No: 198599

Serial No/Batch: S213816

Revision: A

Inspector:

Exp Date:

Instructions: FAA STC SR01583SE 18/10/17, TC STC SH05-

Plex 7/31/19 12:51 PM Dart.lajeunesse.marie

115 Packaging 1-1 - Pick Kit - B4B 4 pcs	9/13/19	0.00 0.00	Packaging 1 - 31	
			Packaging 1 - 32	
			Packaging 1 - 33	
			Packaging 1 - 34	
			Packaging 1 - 35	
			Packaging 1 - 36	
			Packaging 1 - 1 - B4B	
			Packaging 1 - 2 - B4B	
			Packaging 1 - 3 - B4B	
			Packaging 1 - 4 - B4B	
			Packaging 1 - 5 - B4B	
			Packaging 1 - 6 - B4B	
			Packaging 1 - 7 - B4B	
			Packaging 1 - 8 - B4B	
			Packaging 1 - 9 - B4B	
			Packaging 1 - 10 - B4B	
			Packaging 1 - 11 - B4B	
			Packaging 1 - 12 - B4B	
			Packaging 1 - 13 - B4B	
			Packaging 1 - 14 - B4B	
			Packaging 1 - 15 - B4B	
			Packaging 1 - 16 - B4B	
			Packaging 1 - 17 - B4B	
			Packaging 1 - 18 - B4B	
			Packaging 1 - 19 - B4B	
			Packaging 1 - 20 - B4B	
			Packaging 1 - 21 - B4B	
			Packaging 1 - 22 - B4B	
			Packaging 1 - 23 - B4B	
			Packaging 1 - 24 - B4B	
			Packaging 1 - 25 - B4B	
			Packaging 1 - 26 - B4B	
			Packaging 1 - 27 - B4B	
			Packaging 1 - 28 - B4B	
			Packaging 1 - 29 - B4B	
			Packaging 1 - 30 - B4B	
			Packaging 1 - 31 - B4B	
			Packaging 1 - 32 - B4B	
			Packaging 1 - 33 - B4B	
			Packaging 1 - 34 - B4B	
			Packaging 1 - 35 - B4B	
			Packaging 1 - 36 - B4B	
120 QC 4	9/13/19	0.00 0.00	QC 4 - 28	
			QC 4 - 58	
			QC 4 - 69	
			QC 4 - 9	
			QC 4 - 46	
			QC 4 - 68	
			QC 4 - 72	
			QC 4 - 74	
			QC 4 - 75	
130 Packaging 3-1 - Stock - B4B 4 pcs	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	4 pcs	9/13/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
140 QC 21 - SA	4 pcs	9/13/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - Packaging1-4 (Pick Kit)

Descriptions: 120 - QC4 (QC4- 100% Inspect kits for completeness)

130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D412-742-053 Location :FG083

135 - DC (Document Control) Photocopy blue file and create labels per PPP D412-742-053 CHG002

140 - QC21 (QC21- Final Inspection - Work Order Release) NULL

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C44A	Bolt	60 Ea (15 ea)	110-Packaging 1 - Pick Kit	5176409
D412-742-055	Thru-Bolt Full-Length Standard Wearplates, Bell Medium-Fits LH or RH	4 pcs (1 ea)	115-Packaging 1 - Pick Kit	5176409
D5513-1	Bushing	120 pcs (30 ea)	110-Packaging 1 - Pick Kit	5176409
MS21043-3	Nut	60 Ea (15 ea)	110-Packaging 1 - Pick Kit	5176409
D5425-043	Float Skidtube Assembly	4 pcs (1 ea)	115-Packaging 1-1 - Pick Kit - B4B	5176409

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3C44A	60	262	0
	D412-742-055	4	0	0
	D5513-1	120	296	0
	MS21043-3	60	764	0
115-Packaging 1-1 - Pick Kit - B4B	D5425-043	4	9	0

Part Specifications

Specifications could not be found.

Plex 7/31/19 12:51 PM Dart.lajeunesse.marie

Date:

ed:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				Date : _____ Sequence #: _____		QTY Affected : _____ MRB (QS1042) _____		Route update only ☐							
Description Work Order Deviation				Disposition				Completed By											
_____				_____				Lead hand / Supervisor											
_____				_____				QC / QA Coordinator											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			

5.2 D412-742-023 (DART TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -023	Qty -053	Part Number	Description
	X		D412-742-023	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-053	FLOAT SKIDTUBE
		1	D412-742-055	WEARPLATE KIT
		1	D5425-043	FLOAT SKIDTUBE ASSY.
1		*6	*D3672-1	*WASHER
2		30	D5513-1	BUSHING
3		*12	*D5512-1	*CROSSBOLT SPACER
5		*1	*D5525-3	*FLOAT SKIDTUBE
6		*1	*D5483-041	*TOW CAP ASSY.
7		*1	*D5484-041	*AFT CAP ASSY.
12		*18	*D5518-1	*CROSSBOLT SPACER
13		*6	*AN3C5A	*BOLT
14		15	AN3C44A	BOLT
15		*6	*NAS1149C0332R	*WASHER
16		15	MS21043L3	NUT
30	1		D5466-1	SADDLE, FWD INSIDE
31	1		D5467-1	SADDLE, FWD OUTSIDE
32	1		D5468-1	SADDLE, AFT OUTSIDE
33	1		D5469-1	SADDLE, AFT INSIDE
34	16		AN4C6A	BOLT
35	28		MS21043-4	NUT
36	32		NAS1149C0432R	WASHER
37	32		D3672-3	PHENOLIC WASHER
38	8		AN4C52A	BOLT
39	24		D5446-1	BUSHING
40	8		AN6C12A	BOLT
41	8		NAS1149C0632R	WASHER
42	8		D3672-9	WASHER
43	2		D2876	SADDLE SPACER
44	2		D2877	SADDLE SPACER
45	4		D2747	SET SCREW
46	2		D3533-1	SET SCREW
47	4		AN4C7A	BOLT
50	1		D3407-047	TOW RING
51	2		D5482-3	ACETAL WASHER
52	1		D3456-1	WASHER
60	1		D3405-041	GHW LUG
61	1		D3405-043	GHW LUG
62	4		AN4C47A	BOLT
63	8		D5482-1	ACETAL WASHER
71	75**		NAS1149C0332R	WASHER
72	6		D5513-1	BUSHING
73	3		MS21043-3	NUT
74	13		AN3C46A	BOLT

*DENOTES PART IS INCLUDED WITH D5425-043 ASSEMBLY

**INCLUDES ADDITIONAL WASHERS TO COMPENSATE FOR VARIANCE IN STACKUP THICKNESS

DART AEROSPACE LTD		Work Order: 196.2 64
Description: float skid tube assembly		Part Number: D5425-043
Inspection Dwg: D5425-0 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	.500	/			
2.790	+/- .010	2.790	/		vern	mmL-05
10.790	+/- .010	10.790	/		"	
14.790	+/- .010	14.790	/		Tape	
43.120	+/- .010	43.120	/			
44.870	+/- .010	44.870	/			
48.37	+/- .010	48.37	/			
60.37	+/- .010	60.37	/			
64.37	+/- .010	64.37	/			
74.37	+/- .010	74.37	/			
123.328	+/- .010	123.328	/			
125.87	+/- .010	125.37	/			
129.37	+/- .010	129.37	/			
131.12	+/- .010	131.12	/			
134.62	+/- .010	134.62	/			
136.37	+/- .010	136.37	/			
0.500	+/- .010	.497	/		vern	mmL-05
2.690	+/- .010	2.696	/		"	
4.69	+/- .010	4.69	/		"	
18.69	+/- .010	18.69	/		tape	
15.24	+/- .020	15.24	/		"	
21.0	+/- .100	1.0	/		RG	
0.350	+0.000 / - .020	0.341	/		Height	
0.350	+0.000 / - .020	0.340	/		"	
21.0	+/- .100	1.0	/		RG	
13.71	+/- .030	13.740	/		Tape	
0.152	+/- .015	.143	/		Height	
0.250	+/- .015	.238	/		"	
9.35	+/- .030	9.370	/		tape	
0.350	+0.000 / - .020	.338	/		Height	
20.00	+/- .030	20.020	/		tape	
0.250	+/- .015	.245	/		Height	

Measured by: mmL	Checked by: mmL	QC Inspector:
Date: 19/10/24	Date: 19/10/27	Date:

Engineering Approval: (If necessary)			Date:
Rev	Date	Change	Revised by KJ
B	14.07.31	New Issue	Approved